



SAQ  
SIAT

## 1. DESCRIPTION

Submerged arc welding wire conforming standards EN ISO 24598-A S CrMo2 and AWS A5.23 EB3 suitable to join Cr-Mo low alloy steels.

## 2. PRODUCT CHEMICAL COMPOSITION (%)

		C %	Mn %	Si %	P %	S %	Cr %	Ni %	Mo %	Cu %	V %	Nb
Pittarc S1Cr2Mo1	min	0.12	0.40	0.05	-	-	2.35	-	0.90	-	-	-
	max	0.15	0.70	0.25	0.010	0.010	2.60	0.10	1.05	0.20	0.01	0.01
EN ISO 24598-A S S CrMo2	min	0.08	0.30	0.05	-	-	2.20	-	0.90	-	-	-
	max	0.15	0.70	0.25	0.020	0.020	2.80	0.30	1.15	0.3	0.03	0.01
AWS A5.23 EB3	min	0.05	0.40	0.05	-	-	2.25	-	0.90	-	-	-
	max	0.15	0.80	0.30	0.025	0.025	3.00	-	1.10	0.35	-	-

## 3. WIRE DIMENSIONS


Standard diameter (mm) : 1.6 ; 2.0 ; 2.4 ; 3.2 ; 4.0 ; 4.8  
Permissible deviations : ISO 544

## 4. STANDARD PACKAGING :

Wire basket rim LC (ISO 544 B450) of 27kg net weight. Each spool sealed in a polyethylene airtight bag and packed into a cardboard box. 42 spools stacked onto a pallet secured by thermoplastic shrink-wrapping (120 x 80 cm, 1134kg net weight). Available cardboard drums of about 320kg net weight, each one stacked onto a pallet 110x110cm of about 1280kg total weight (4 drums), secured by thermoplastic shrink-wrapping. On request packaging available from 15 kg up to 900 kg.

## 5. STANDARD IDENTIFICATION

A label is attached to the inside of each spool or drums and to every box or outside of the drums mentioning manufacturer, trade name, nominal diameter, spool type, net weight, heat number, standards.

	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY		
<b>PITTARC S1Cr2Mo1</b>			
Welding wire for carbon steels and fine-grained steels EN ISO 24598-A S CrMo2 AWS A5.23 EB3			
Weight kg	Heat N°	Diameter	Spool type
XX	XXXX/XX	X.X mm	X XXX

## 6. STANDARD CERTIFICATION

Documents according to EN 10204

## 7. APPROVALS

NONE